



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

D3438-042
Job Sheet 174230



Part No: D3438-042

Job Qty: 2 ea

Part Name: Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/13/18

Job Tracking No:

Due Date: 4/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 05.05.18 New Issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		4/2/18	0.00	0.00	Start Up Large Fab-4		DC 2018-04-03
100	Large Fab	2 pcs		4/2/18	0.00	2.56	Large Fab 2		DC 2018-04-03 S.L.
110	QC	2 pcs		4/2/18	0.00	0.00	QC9		CPC
120	QC	2 pcs		4/2/18	0.00	0.00	QC5		CPC
130	HandFinish	2 pcs		4/2/18	0.00	0.97	HandFinish1		SA 18-04-06
140	QC	2 pcs		4/2/18	0.00	0.00	QC3		CPC
150	Large Fab	2 pcs		4/2/18	0.00	2.56	Large Fab 2		S.L.
160	QC	2 pcs		4/2/18	0.00	0.00	QC10		CPC
170	QC	2 pcs		4/2/18	0.00	0.00	QC5		CPC
175	HandFinish	2 pcs		4/2/18	0.00	0.20	HandFinish6		SA 18-04-09
180	Powdercoat	2 pcs		4/2/18	0.00	0.28	Powdercoat1		BR/BEB 18-4-10
190	HandFinish	2 pcs		4/3/18	0.00	0.97	HandFinish3		BEB 18-04-11
200	QC	2 pcs		4/3/18	0.00	0.00	QC3		11 APR 12 2018
210	Packaging	2 pcs		4/3/18	0.00	0.00	Packaging3-1		9-89
220	QC21-SA	2 Ea		4/3/18	0.00	0.00	QC21		DAS APR 12 2018

Part Op 100 - 1-Cut D2244 to 79.63" at 34° as per Dwg D3438 3-Weld one cap, LUG PLATES & MOUNTING ANGLE as per Dwg Descriptions: D3438 using DT8343 4-Grind

150 - Weld last cap per dwg D3438 & grind flush

175 - Touch up alodine

180 - 1-Touch up alodine

190 - Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561 lugs

Wing walk M138761

M 138760

START: 11:00

OUT: 3:00 PM FINISH: 11:30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2 Ea (1 ea)	90-Start up Operation	5014552
D2561	Lug	4 Ea (2 ea)	90-Start up Operation	5041261
D2673-34	End Plate	4 Ea (2 ea)	90-Start up Operation	5042088
D2564	Mounting Angle	4 Ea (2 ea)	90-Start up Operation	5042481 (3x) 5052121 (1x)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	2	168	0
	D2561	4	20	0
	D2564	4	15	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other	AGAINST DEPARTMENT/PROCESS		
Date :	Step #:	QTY Effective :	MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		
		Completed By		
		Lead hand / Supervisor Approval Verification		
		QC / QA Coordinator Approval		
Root Cause ☐ Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		
☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence				
OTHER : _____				

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

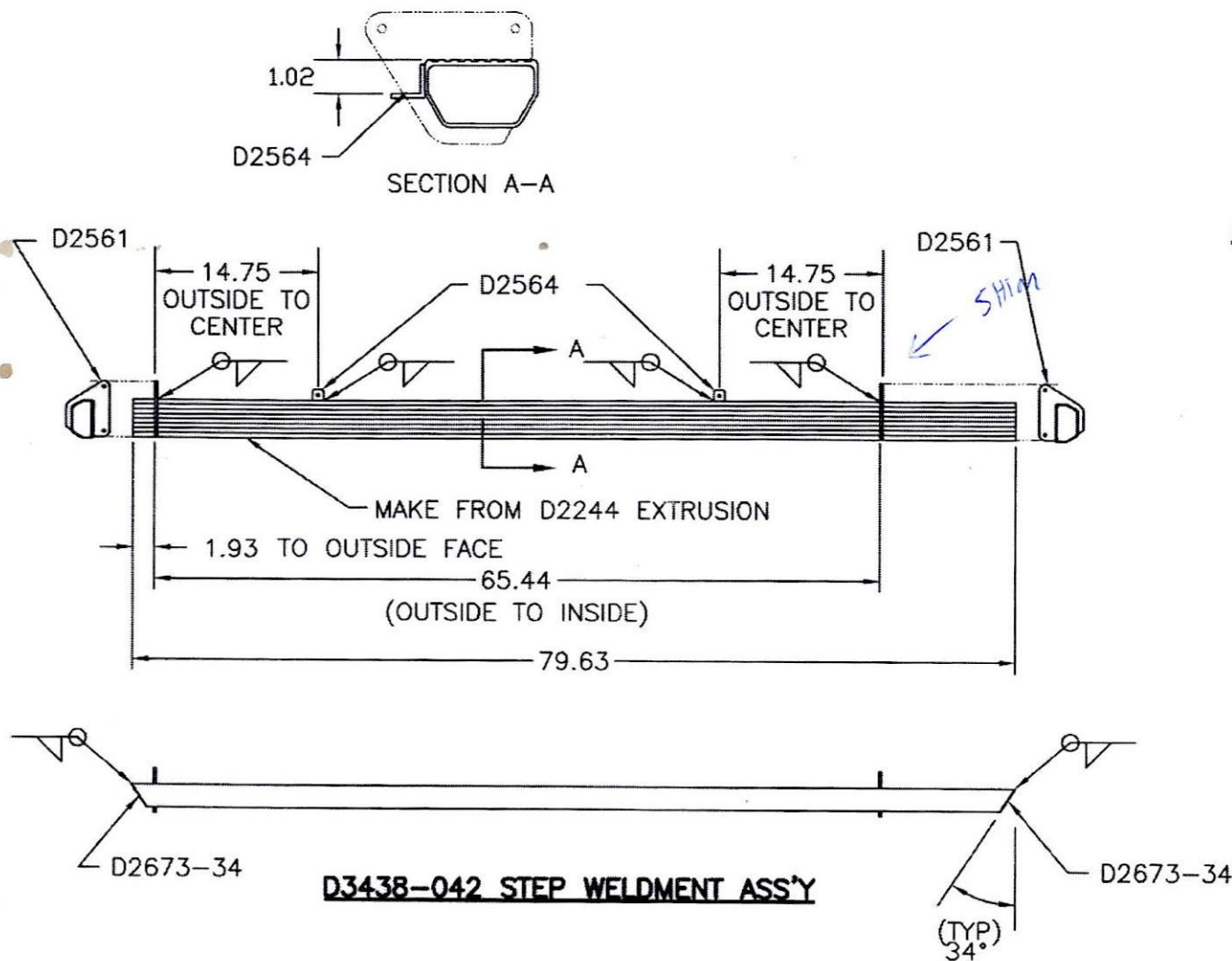
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART

RELEASED

05.05.22

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.05.09	TITLE	D3438	REV. A
		STEP WELDMENT ASSEMBLY		SHEET 1 OF 1
A	05.05.09	NEW ISSUE		SCALE 1:1



NOTES:

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1 WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS



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Container No: S057846



Part: D3438-042

Job No: 174230

Serial No/Batch: S057846

Revision:

Inspector:

Master Unit 002188



Job No 174230

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